

79058

January-19-12 9:30:15 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

Customer:

12

12

Run Start *NR1*

Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Draw Nbr	Revision Nbr
D3535	Rev B

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Debur if necessary

304.040

110

QC2- Inspect parts off machine FAI/FAIB

0.00

*** 1 1 0 ***

Memo

0.00

QC

Quality Control

120

QC8- Inspect parts - second check

0.00

120

Memo

0.00

QC

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79058

January-19-12 9:30:15 AM

79058

Page 2

Item ID: D3535-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 19/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	NC BRAKE	0.00							
-----	----------	------	--	--	--	--	--	--	--

130

Brake NC

Brake NC

Memo

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form
 joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-11

SB 12/02/23

15

140	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

0.00

ml 12.02.23 15

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	--	------	--	--	--	--	--	--	--

150

Powdercoat

Powder Coating

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

12h30

15 (DP) ml 12/02/27 2012 12/02/27

MC18489

Dart Aerospace Ltd

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Work Order ID 79058

79058

Page 3

January-19-12 9:30:15 AM

Item ID: D3535-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 19/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							15 x 0 12/02/27 counted & measured
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FPI</u> Memo	0.00 0.00							15 x 0 @ 12/02/27
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ 12/02/28 12-02-27 (15)

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NOTE: Date & initial all entries

Picklist Print

January-19-12 9:30:19 AM

Page 1

Work Order ID: 79058

79058

Parent Item: D3535-11

D3535-11

Parent Item Name: Wearshoe

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	225.5165	0.7015	8.861053	10		

M304S20GA

**

B12-2-18

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

225.5165

116623

0.2

117933

27.3442

118400

25.6723

118964

36.5

119346

135.8

120604

15

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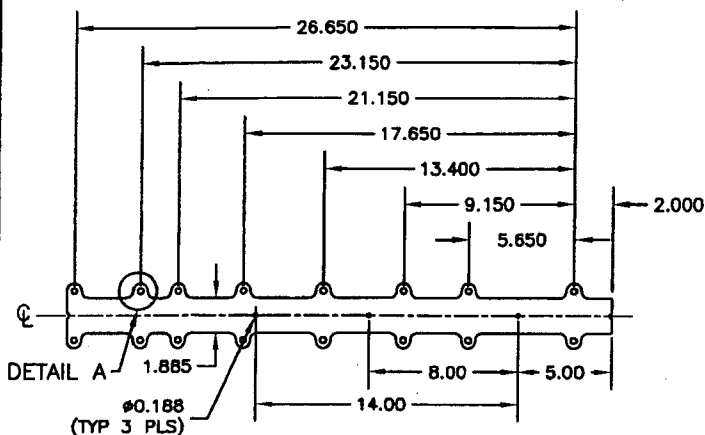
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DART

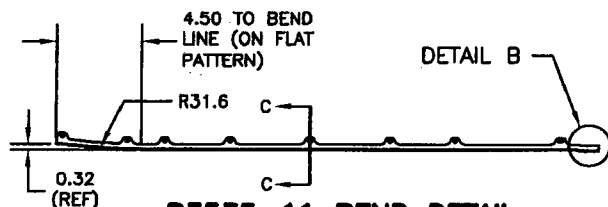
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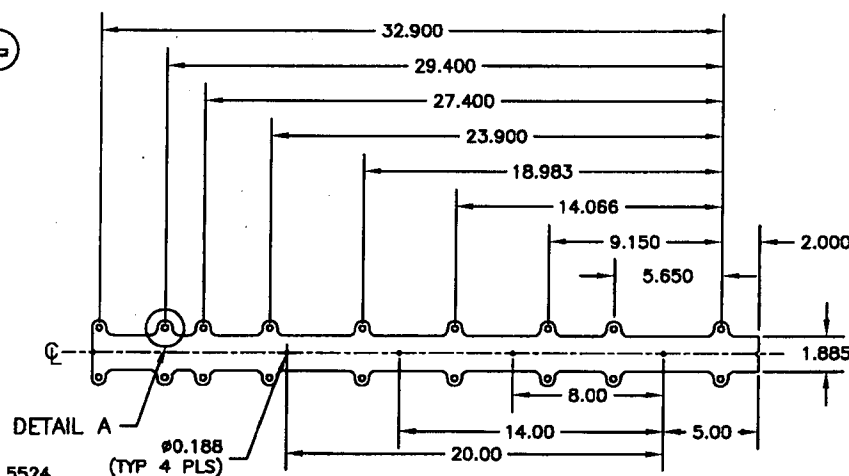
SUBJECT
UNCOMPLETED
SUBJECT
WITH
NO. 79058 H.C.S
12/01/19



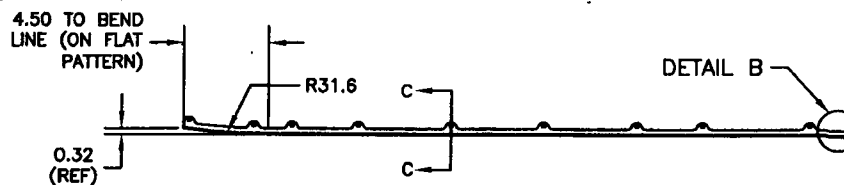
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. B
CB	PH	D3535		
CHECKED	APPROVED	D3535	SHEET 1 OF 7	
DATE	TITLE	WEARSHOE	SCALE	
07.04.17			1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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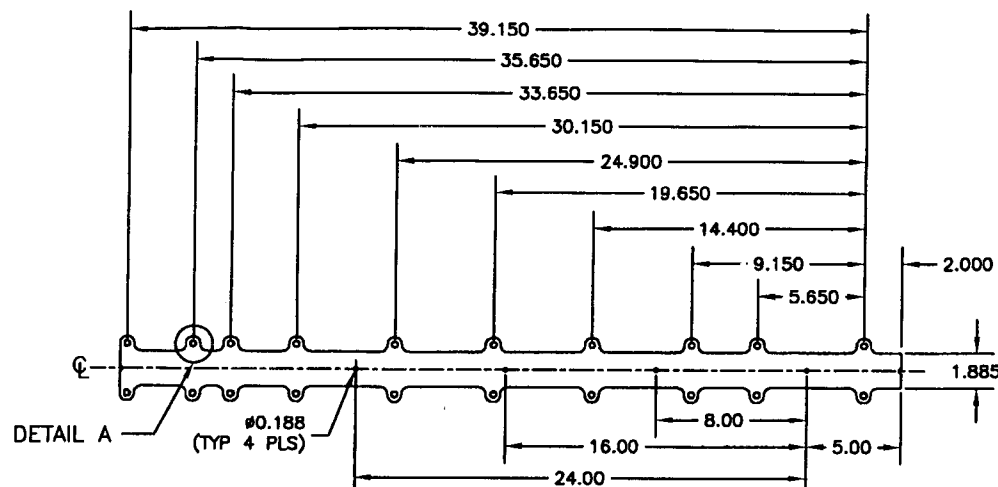
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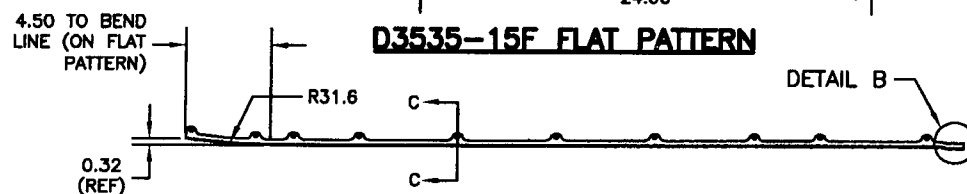
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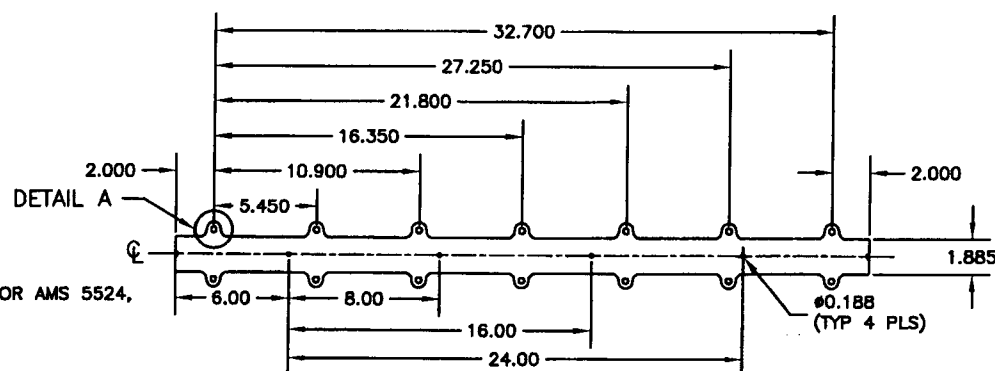
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DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 2 OF 7		
		REV. B		



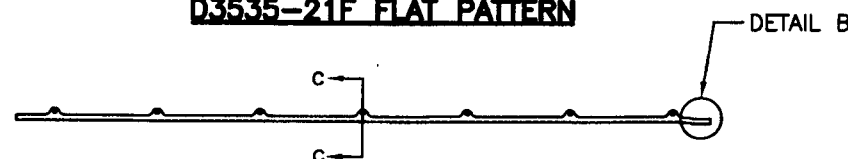
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

Dart Aerospace Ltd

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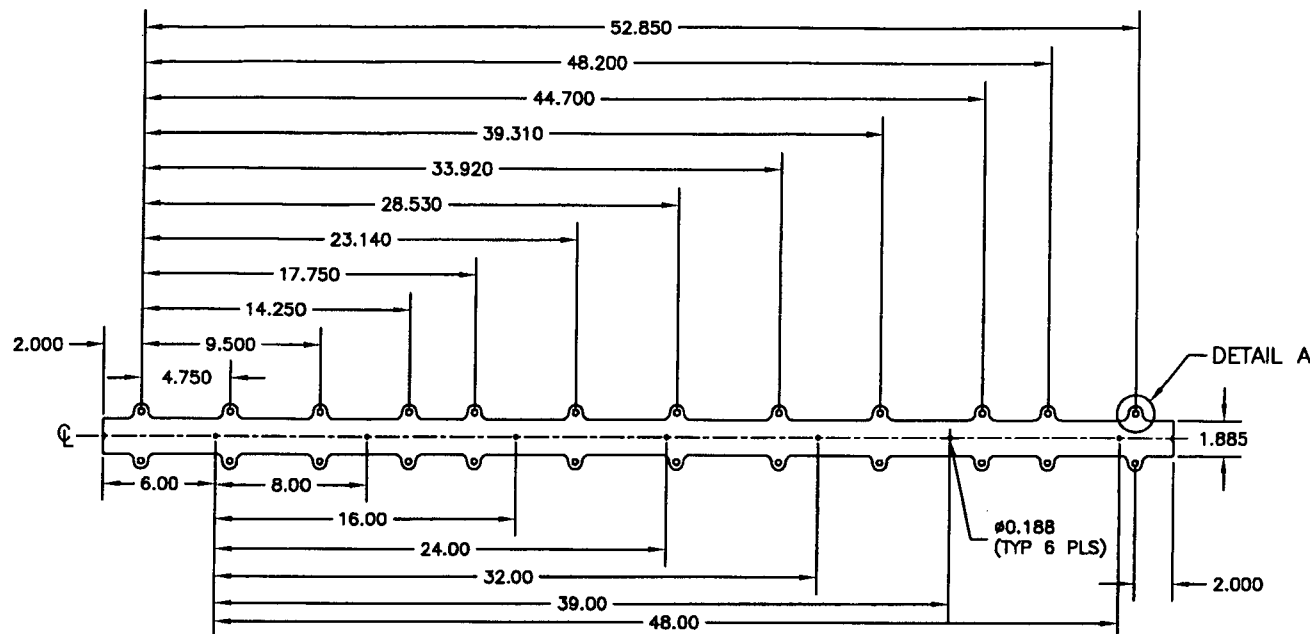
NOTE: Date & initial all entries

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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	

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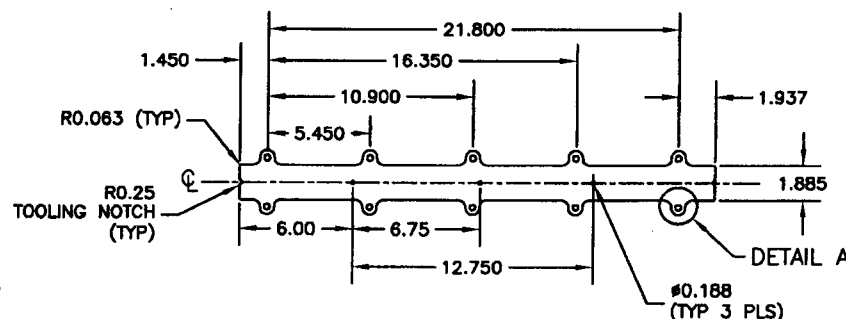
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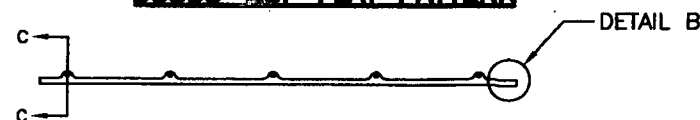
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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Dart Aerospace Ltd

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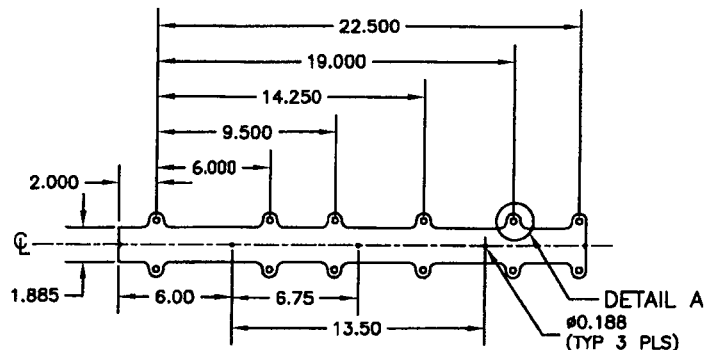
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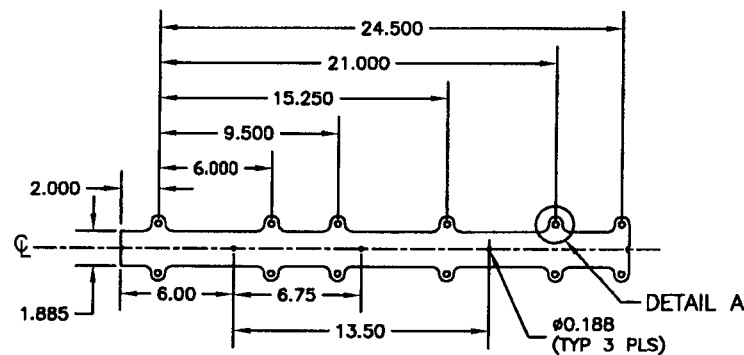
07.04.24



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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C.B.	M.	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 4 OF 7
		SCALE 1:10

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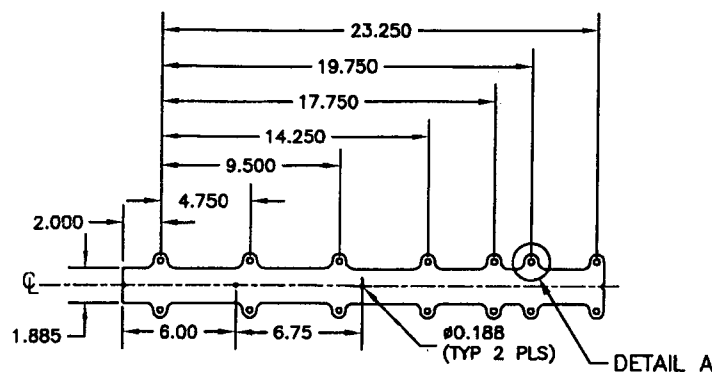
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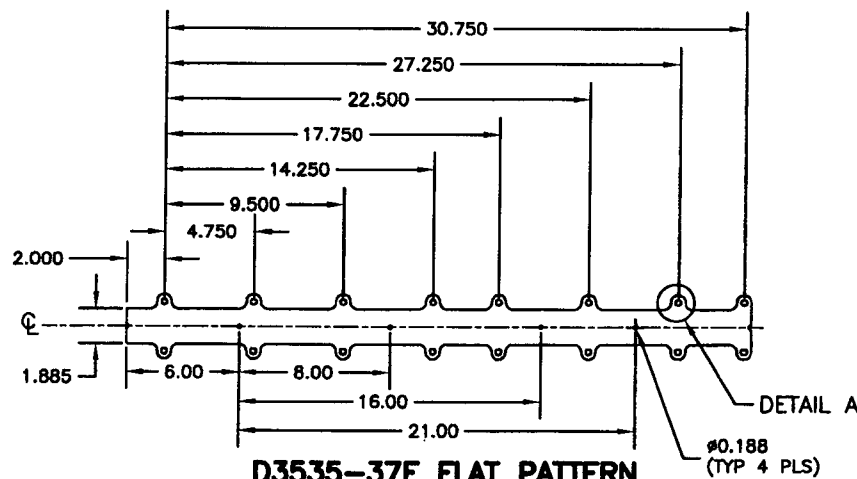
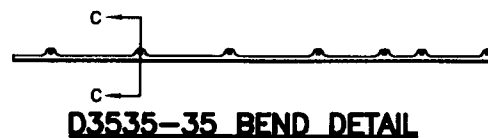
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7
	SCALE 1:10	



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



NOTES

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PORT HADLOCK, WA

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DRAWING NO.

REV. B

DATE

DATE

TITLE

SHEET 6 OF 7

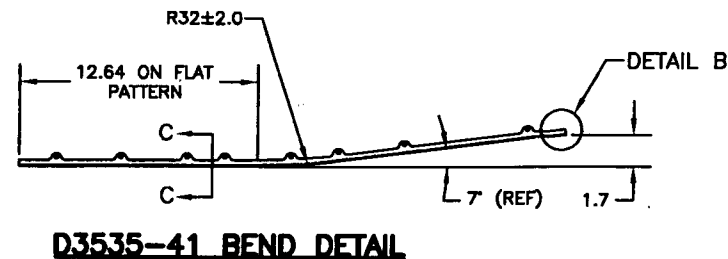
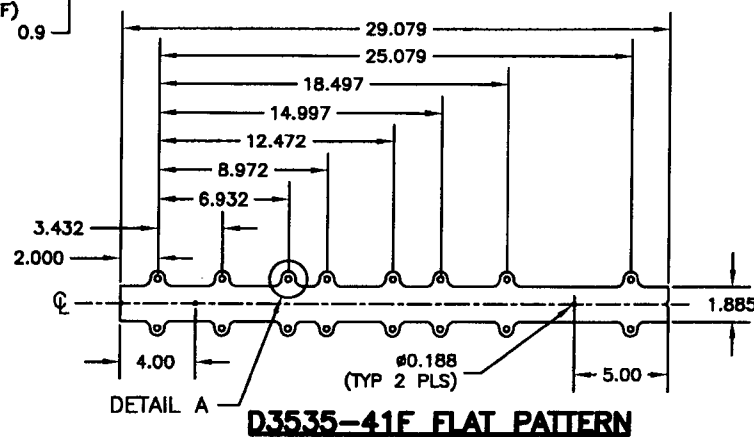
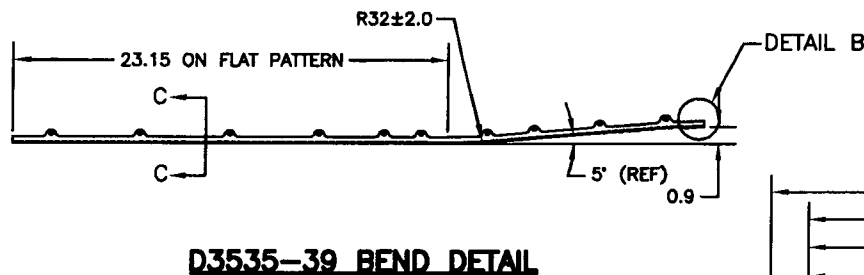
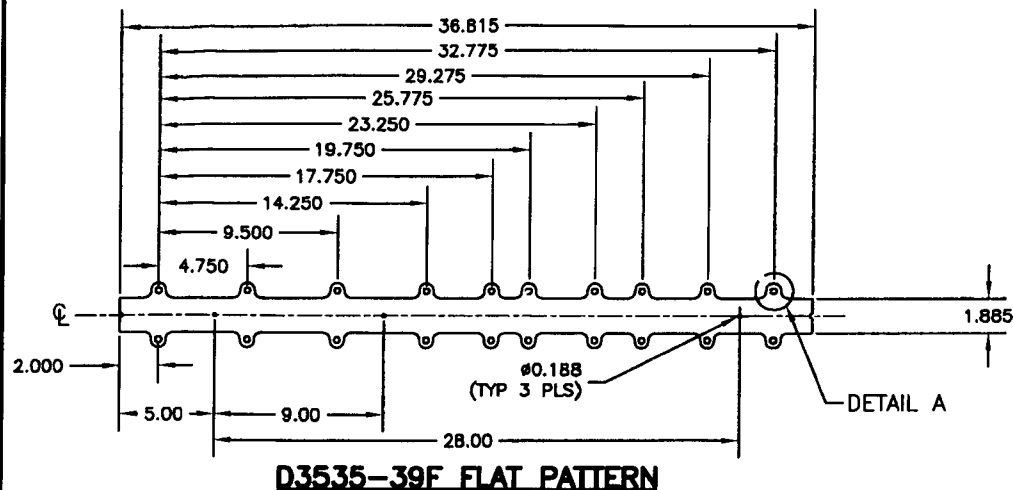
07.04.17

WEARSHOE

SCALE
1:10

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07.04.24



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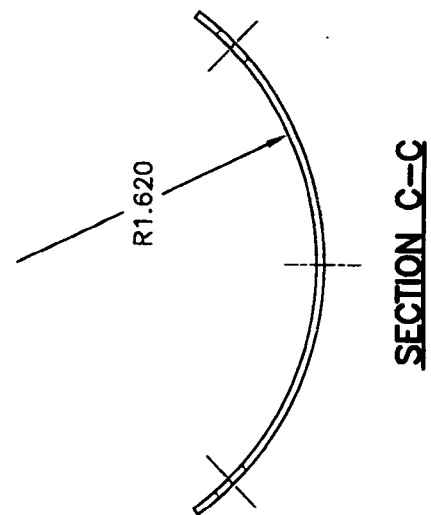
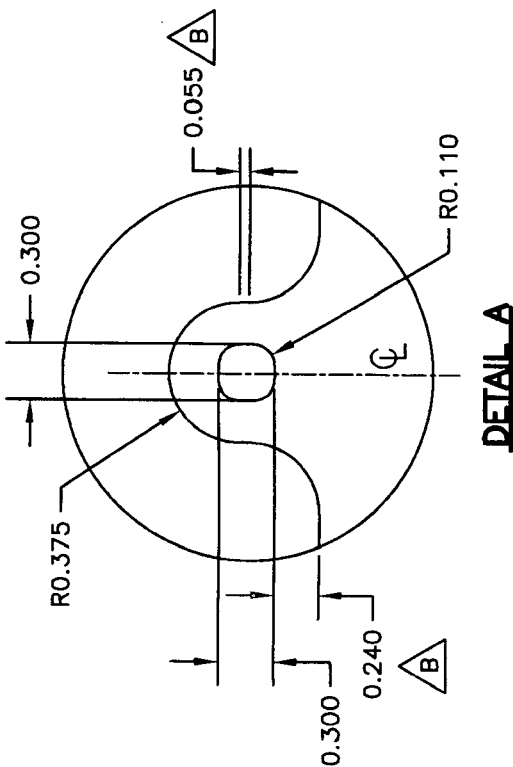
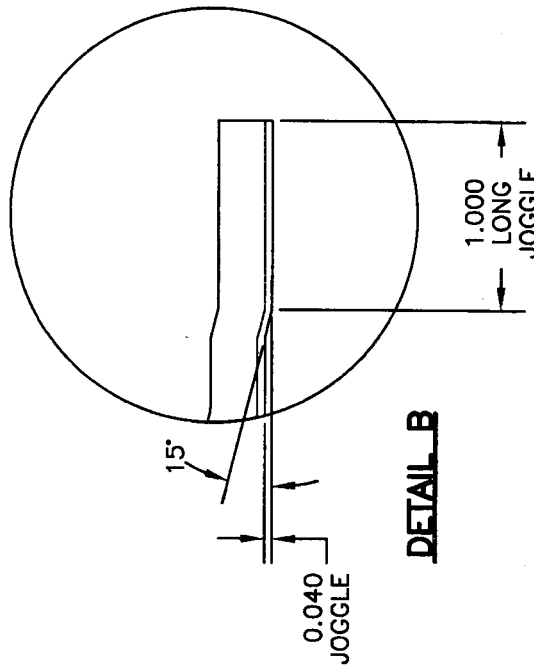
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

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07.04.24



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